Work Order l Friday, October 24,			*125	908*	·						Page 1	
Revision ID:  Item Name: Wes	535-25  Arplate Center  27/14 Start Qty: 50.0	<i>;</i>	Accept	*N900		100	<b>n</b> *	Setup	Start Stop	171	S1* S2*	<del></del>
Required Date: 11/2 Reference:				Customer								
Approvals: Pr	ocess Plan:	Date: 14-10-24  Date:	Tooling: SPC (Y/N):		)ate: )ate:			Run	Start Stop	*N	R1* R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr D3535	Revision Nbr Rev B				·			,			DA	
*1 \\n\* Waterjet FLOW CNC Waterjet 304 \cdot 040^*		per Dwg D3535 Dwg Rev:_ f necessary	0.00  0.00  Prog Rev: B	2-			<b>6</b>	<del></del>		De 14/	2: /1 <u>8 / 0 ;</u>	
110 *110* QC Quality Control	QC2- Inspect parts of  Memo	ff machine FAI/FAIB	0.00	-			<u></u>			oc /4	<u>/11 /01</u>	DA 2: 9-8
120 *1 20* OC Quality Control	QC8- Inspect parts - s <b>Memo</b>	second check	0.00		·		<u> (30)</u>				DAS 38 9-89 NOV 0 3	3 2014

DQA:			Date:			WORK ORDER NON	C	ONEOI	DNANICE / I	IDDATE				,	<b>P</b> AÀRT
QA Closed:			Date:			WORK ORDER NOW		JINFOI	MIVIAINCE / C		Wor	k Order up	odate only	Γ	A E R O S P A C E
Work Orde	or.					DISPOSITION				AGAINST	DEP	ARTMENT	/PROCESS		
Part N	 No					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Je d. Eng. Coor re/Packaging Supplie		Engineering Quality Other
Root					Desci	ription of work order update		Initial	Ac	tion	Т	Sign &			
Cause		Date	Step	Qty		or non-conformance	Cr	nief Eng	Desc	cription		Date	Verification	on	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved						/								•	
							FAI	ULT CAT	EGORY						
Landir	Bo Co Co Co Co Co Co M H	ending entre No racks rimp/Kin uffs rushing eat Trea ispection larks/Ch	Strip in	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/U ions Incomplete/ ned/off center led	` <b>}</b>	P P	Outside Dime Over/Under art Incorrect art Lost/Mis art Moved ositioned Wower Loss/S	tolerance st ssing /rong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Jw	/ave/Twi	ist in Tub	e		Fit/Function		Out of S	equence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

<b>Work Ord</b> Friday, October				*125	5908*						Page	2
Item ID: Revision ID: Item Name:	D3535-25 Wearplate Ce	nter		Accept	*N900	040	100	)* ፡	Setup Sta	. ! /	S1* S2*	
Start Date: Required Date: Reference:	10/27/14 : 11/28/14	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*		Cust Item l Customer:	ID:						
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		F	Run Sta Sto	רו י מ	R1* R2*	
Sequence ID/ Work Center II 130	D	Operation Description		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	ylide.
*130* Brake NC			NC Brake as per Dwg D3: on Punch as per Dwg D35	2 2			<b>30</b> 9-89	<u> 56</u>				DAS 36 9-89
140		QC5- Inspect part comple	, 0	0.00	·						DAS	

\*140\*

Quality Control

Memo

0.00

50 \$ H-11-6

NOV 0 5 2014

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

\*150\* Powdercoat

Powder Coating

DQA:			. Date:			- WORK ORDER NON	1 6	SNEOI		DATE			DART
QA Closed:			Date:			WORK ORDER NON	1-C(	JNFO	KIVIANCE / UI		ork Order u	odate only	AEROSPACE
Work Orde	er:					DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part N NCR N	-					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	<b>⊣</b>	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause		Date	Step	Qty	Desc	ription of work order update or non-conformance	1	nitial iief Eng	Act Descr		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved							FAI	ULT CA1	TEGORY				
Landir	ng G	ear				General						18. 11. 12. 1	
		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S Wave/Tw	nk/Ripple ot n Strip in natter equence	/Wave Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish Fit/Function		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	re ion Incomplete/Un ions Incomplete/U ined/off center iled	<u> </u>	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other

\*\*

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1	·		16-7-1										
Work Ord Friday, Octobe					*12!	5908*							Page 3
Item ID: Revision ID: Item Name:	D3535-25 Wearplate Co	enter			Accept	*N900	<u>04</u> 0	110	<b>N</b> *	Setup	Star Stop	1/	IS1* IS2*
Start Date: Required Date Reference:	10/27/14 e: 11/28/14	Start Qty: 50.00 Req'd Qty: 50.00		*50* *50*		Cust Item 1 Customer:	ID:						
Approvals:	Process Pl	an:	Date:		Tooling:	D	ate:			Run	Start	^ \	IR1*
	QC:		Date:		SPC (Y/N):	D	ate:				Stop	*/	IR2*
Sequence ID/ Work Center	ID	Operation Description QC3- Inspect Part Finish			Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty	ject y	Reject Number	Insp. Stamp DAS 38
*1 60* QC Quality Control		Memo			0.00				(50)				9-89 NOV 0 7 2014
170		Identify as per dwg & Sto	ck Location:	FP-602	0.00	,					ſ		
*170* Packaging Packaging		Memo			0.00				_ X 50	) 	<u>d</u>	<u> </u>	<u> </u>

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

180

\*1 20\*

Quality Control

DQA:			. Date:				_						N	DART
QA Closed:			Date:			WORK ORDER NON	-C(	ONFO	RMANCE / U		Work Order u	odate only	_	AEROSPACE
· · · · · · · · · · · · · · · · · · ·						DISPOSITION					DEPARTMENT	, ,		
Work Orde	er: _						1			_	<del></del>	_		
Part N	10					Rework Scrap			Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.		Engineering Quality
NCR N	10				<del></del>	Use-as-is Suspected Unapproved	]	Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier		Other
Root					Desc	ription of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Cł	nief Eng	Desc	ription	Date	Verification		QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
Ollapproved			1				FΔI	ULT CAT	FGORY			<u> </u>		
Landir	ng Ge	ar				General								
		racks	ot Concen ik/Ripple,			Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink		Instruct		· —	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	tolerance ct ssing	S T	ressure/Forced et-up emperature/Cure Veld Vrong Stock Pulled
	Н	eat Trea	t			Cut Too Short		Mislabe	led		Power Loss/	Surge	0	ther
	ln	spection	n Strip in	Tube		Drawing		Misread						
	м	larks/Ch	atter			Drill Holes		Off-set						
	_	_	equence	-		Finish		Out of C	Calibration					
[	lν	/ave/Tw	ist in Tub	e		Fit/Function		Out of s	equence					

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## **Picklist Print**

Friday, October 24, 2014 11:13:24 AM

Work Order ID: 125908

\*125908\*

Parent Item:

D3535-25

\*D3535-25\*

Parent Item Name: Wearplate Center

**Start Date:** 10/27/14

Required Date: 11/28/14

Page 1

**Start Qty: 50.00** 

Required Qty: 50.00

**Comments:** 

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		rimary ocation	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M304S20GA		Purchased	No			100	sf	161.6939	0.51	27		/		DAS
<b>*N4004000</b>	~ ^ +								44			/	100	23

\*M304S20GA\*

304/316 .040 Sheet

Location	Loc Oty	Loc Code	
MAT020	161.6938948		
m126852	0.31		
m127454	26.1018948		
m128435	81.14		
m129845	28.89		
m130345 130745	25.252		34.233

DQA:			Date:			_							**	NA DT
						<b>WORK ORDER NON</b>	I-C	ONFO	RMANCE / U	PDATE				AEROSPACE
QA Closed:			Date:							٧	Vork Order uj	odate only		
Work Orde	·r·					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
WORK Orac	٠.					Rework	7	i	Skid-tube	Crosstube	٦	Water Jet		Engineering
Part N	ο.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	$\dashv$	Quality
	•					Use-as-is	1		noforming	Finishing	<del>-</del>	re/Packaging		Other
NCR N	ο.			··· <del>-</del>		Suspected Unapproved			Large Fab	Composite		Supplier		
Root					Desc	ription of work order update	T	Initial	Act	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance		nief Eng	Desci	ription	Date	Verification	า	QC Inspector
Design		- · · · · · · · · · · · · · · · · · · ·												
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator													ŀ	
Offset/Setup														•
Process	_													
Supplier														
Training														
Transport	_								·					
Unapproved							<u></u>				<u> </u>			
							FA	ULT CAT	regory					
Landin						General	_	]		<u></u>	٦			
	-	Bending			-	Bend BOM/Bouts	-	1	rogram	<u> </u>	Outside Dim		_	Pressure/Forced
ļ <u> </u>	ᅴ	Centre No Cracks	ot Concen	ILTIC		BOM/Route Broken/Damage/Defect	$\vdash$	Grain		<del> </del>	Over/Under	,		Set-up
}	$\dashv$	Crimp/Kin	d /Binala	Mayo	-	Burrs	$\vdash$	Hardwa	re on Incomplete/Ur		Part Incorred	· · · · · · · · · · · · · · · · · · ·	$\neg$	Temperature/Cure
-		Cuffs	ik/ Kippie/	vvave	-		$\vdash$	1 '	•	· · · · · · · · · · · · · · · · · · ·	Part Lost/Mi	ssing		Weld
		Crushing			-	Contamination Countersink	$\vdash$	1	ions Incomplete/l	Inclear	Part Moved	lrana [		Wrong Stock Pulled
-	$\neg$	Heat Trea	t .		-	Cut Too Short	-	Mislabe	ned/off center	-	Positioned V Power Loss/	· ·	<u> </u>	Other
-		Inspection		Tuhe		Drawing	-	Misreac		L	Trower ross/:	oni Re [		Outer
-	_	Marks/Ch		TUDE		Drill Holes	-	Off-set	4		<del> </del>			
-	_	Turning Se			-	Finish	$\vdash$	4	Calibration					
	_	Wave/Tw		e		Fit/Function	$\vdash$	4	Sequence					

DART AEROSPACE LTD	Work Order:	125908
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

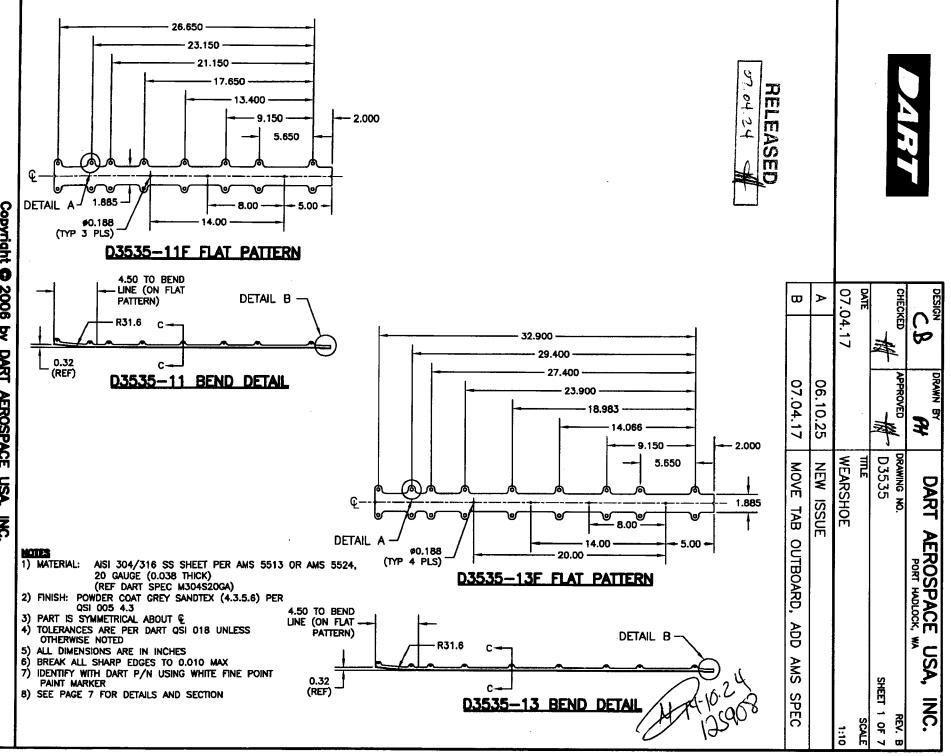
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.885	1	-	V=5KM-G1	
1.937	+/-0.010	1.937	/		T=5kM-01	
1.450	+/-0.010	1450	/		U=5KM -08	
5.450	+/-0.010	5.450	-			
10.900	+/-0.010	10.900	/			
16.350	+/-0.010	16.350	1			
21.800	+/-0.010	21.900				
Ø0.188	+0.005/-0.001	ø .192	_		,	
12.750	+/-0.010	12.750				
6.75	+/-0.030	6.75	_			
6.00	+/-0.030	6.00	/		,	
0.300	+/-0.010	.303	_			
0.300	+/-0.010	. 304	_			
0.038	+/-0.010	.636	_			
			_			
				-		
			DAS			

Measured by: 23 Audited by: 9-89 Prototype Approval: N/A

Date: /4/14/01 Date: NOV 0 3 2014 Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD J/	. 1
				— <del>[-43</del> ——

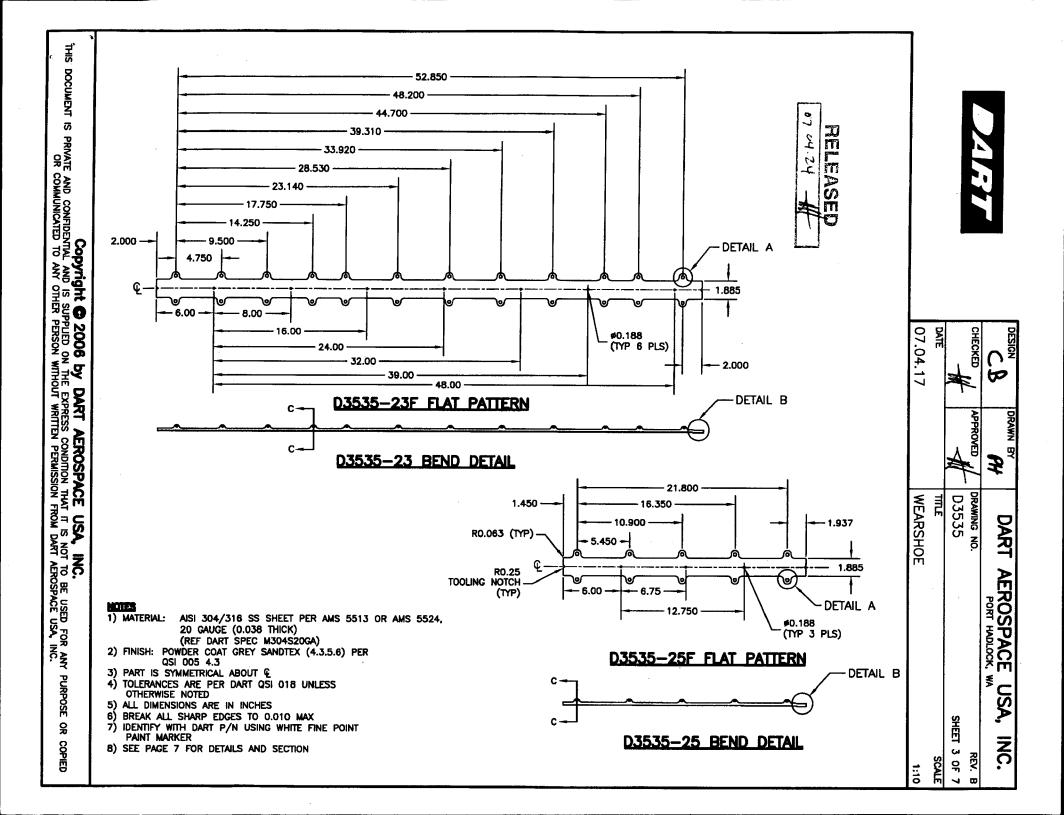


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COPIED





DATE

07.04.17

WEARSHOE

CHECKED

APPROVED

DRAWING NO.

SHEET

**4** 약

1:10

B

3

DART

AEROSPACE PORT HADLOCK,

RC.



c - c -

D3535-31 BEND DETAIL

5513 OR AMS 5524,

D3535-31F FLAT PATTERN

--- 22.500 ·

DETAIL A #0.188 (TYP 3 PLS)

14.250

9.500

6.000 --

2.000

1.885

24.500 21.000 9.500 6.00 6.00 6.75 13.50 DETAIL A O.188 (TYP 3 PLS)

ES.	
MATERIAL:	AISI 304/316 SS SHEET PER AMS
	20 GAUGE (0.038 THICK)
	(REE DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

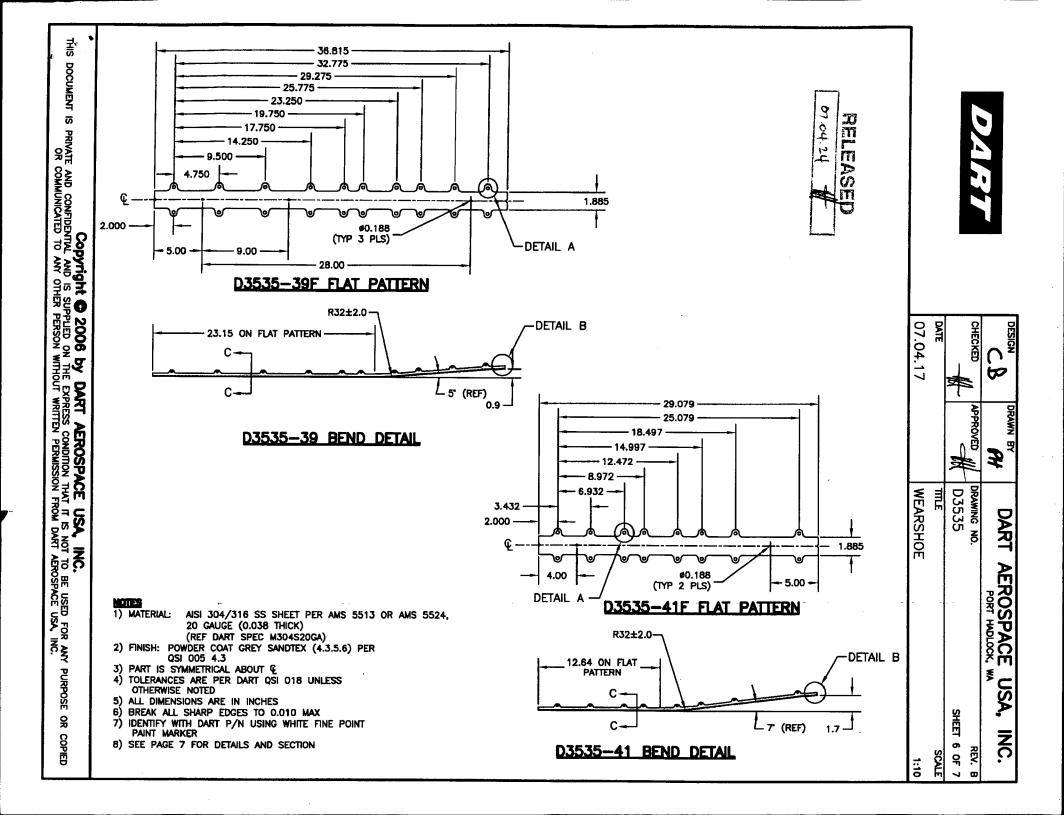
8) SEE PAGE 7 FOR DETAILS AND SECTION



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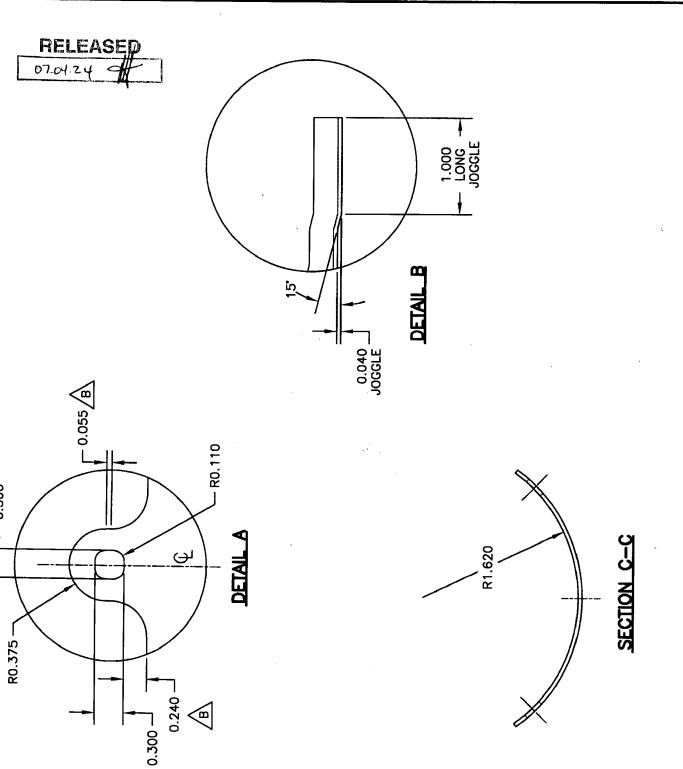
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DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED XX	APPROVED #/	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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